

Date: Tuesday, 29/05/2007 10:53:48 AM
 User: Linda Lacelle

Process Sheet

Split 20706-11

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STRUT ASSEMBLY	
Job Number	: 32710-2				
Estimate Number	: 10808				
P.O. Number	: N/A		Part Number	: D3180041	
This Issue	: 29/05/2007 S.O. No. : N/A		Drawing Number	: D3180-PRELIMINARY	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: A	
Previous Run	: 32328		Material	: N/A	
Written By			Due Date	: 01/06/2007	
Checked & Approved By			Qty:	3	
Comment	: Est Rev:A 03.01.27 New issue KJ/RF		Um:	Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	
Comment: Qty.: 3.7625 f(s)/Unit Total: 3.7625 f(s) 304/316 Seamless Tubing with 3/4" O.D. x 0.049" wall (M304TR0.750W0.049) Batch: 7104565			
2.0	BRAKE NC	NC BRAKE	
Comment: NC BRAKE			
1-Punch 304/316 Seamless Tubing with 3/4" O.D. x 0.049" wall to length as per Dwg D3180 using DT8313 Ensure rotate and punch one end only as per view B-B as per Dwg. D3180			
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
Comment: SMALL & MEDIUM FAB RESOURCE 1			
1-Drill Ø0.203" as per Dwg D3180			
2-Bend one side only as per Dwg D3180 Identify as D3180-1			
3-Deburr edges			
4.0	QC5	INSPECT WORK TO CURRENT STEP ENGINEERING APPROVAL	
Comment: INSPECT WORK TO CURRENT STEP			
07.05.30			

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 10341

BR

07-05-31

(PTD)
③

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L



07/06/04

(3X)

7.0 D2022101

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2022-101 Spacer B30543



8.0 D26906

Lanyard



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2690-6 Lanyard M28519

①

②
31191.

9.0 A1449

Grommet



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3180-1(ref) Strut B32710

1 A1449 Grommet M1487.

10.0 AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 AN960JD10 Washer M10418

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Part Number: D3180041

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 BLRS001 Pip Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 BLRS-001 Pip Pin M15608-

12.0 MS21042L3 Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 MS21042L3 Nut (or -3) M10369/

13.0 MS27039110 Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 MS27039-1-10 Screw 18836 7/6/4 SO/

14.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3180

FF 07-06-04

15.0 QC5 INSPECT WORK TO CURRENT STEP



2020605(3)



Comment: INSPECT WORK TO CURRENT STEP

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Job Number:



Seq. #: Machine Or Operation:

Description :

16.0 PACKAGING 1

PACKAGING RESOURCE #1



P10

1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

~~FOR ENGINEERING USE ONLY~~

R 7/6/11 S9

17.0 QC21

FINAL INSPECTION/W/O RELEASE



1

Comment: FINAL INSPECTION/W/O RELEASE

7/6/11

Job Completion



W. J. doll OK TO MANUFACTURE UP TO STEP 15
DO NOT PASS STEP 15

POSITIVE RECALL

EFFECTIVE 07/06/11 AUTH Y

RELEASED 07/06/11 DATE 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prog Mgr	Approval QC Inspector
07-06-11	160	split w/o for a qty of 1 to ship to a customer.	J	07-06-11	1	07-06-11	07-06-11

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries